

Now!

Work Order ID 74153



Page 1

Monday, September 26, 2011 10:21:24 AM

Item ID: D3911-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Installation Stud, Lower

Start Date: 9/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3911                          | D                        |                      |         |        |              |               |               |                  |                |

110

0.00



Doosan

Memo

0.00

Doosan Lathe

1-Mill as per folio FA831 & dwg,

FOLIO REV: 1

DWG REV: 1

~~2 GRIND 13" RAD MANUALLY~~

3-Deburr as required

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 74153



Page 2

Monday, September 26, 2011 10:21:24 AM

Item ID: D3911-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Installation Stud, Lower

Start Date: 9/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130 QC8- Inspect parts - second check

0.00

SL 11-09-28



QC Memo

0.00

Quality Control

140 Identify as per dwg & Stock Location: Sylvia

0.00

SB 11/09/29



Packaging Memo

0.00

Packaging

150 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

11/10/30  
MUF  
11-09-29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 26, 2011 10:21:22 AM

Page 1

Work Order ID: 74153



Parent Item: D3911-1



Parent Item Name: Basket Installation Stud, Lower

Start Date: 9/26/2011

Required Date: 9/28/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC  
AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M303R1.000

Purchased

No

110

f

33.3390

0.25

2.103263



303 Round Bar 1.00

11/9/25

Location

Loc Qty

Loc Code

MAT028

33.339

116700

1.107

117550

5.7

117598

13.74

118008

12.792

2.7

4/22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

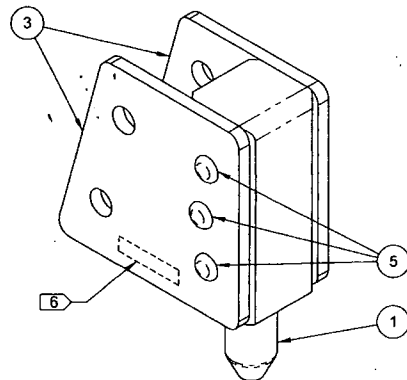
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



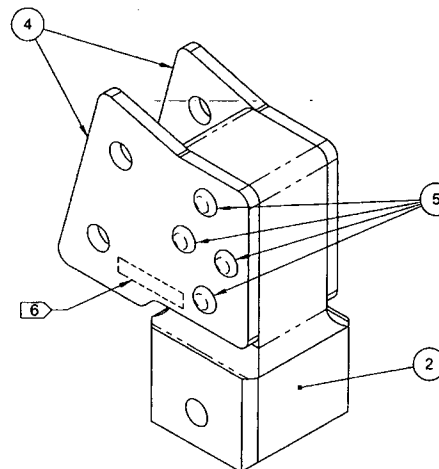
| ITEM | QTY<br>-041 | QTY<br>-043 | P/N          | DESCRIPTION                    |
|------|-------------|-------------|--------------|--------------------------------|
|      | X           |             | D3911-041    | BASKET INSTL STUD ASSY (LOWER) |
|      |             | X           | D3911-043    | AFT EYEBOLT RECEIVER ASSY      |
| 1    | 1           |             | D3911-1      | BASKET INSTL STUD (LOWER)      |
| 2    |             | 1           | D3911-3      | AFT EYEBOLT RECEIVER           |
| 3    | 2           |             | D3911-5      | BASKET STUD PLATE              |
| 4    |             | 2           | D3911-7      | BASKET PLATE-EYEBOLT RECEIVER  |
| 5    | 3           | 4           | MS20615-4M20 | RIVET                          |



**D3911-041 BASKET INSTL STUD ASSY (LOWER)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs  
-043: 0.99 lbs



**D3911-043 AFT EYEBOLT RECEIVER ASSY**

*w/o 74153*

**RELEASED**  
2010-08-06

|            |   |  |              |
|------------|---|--|--------------|
| D          | 0.825 +0.000/-0.010 WAS 0.65 (B1-2).  | MB   | 10.06.22     |
| C          | BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3). | JPH  | 10.04.06     |
| B          | DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)   | JPH  | 10.03.16     |
| A          | NEW ISSUE   | JPH  | 10.03.04     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | JPH   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      |   |  |              |
| CHECKED    |   | DRAWING NO.  | REV. D       |
| MFG. APPR. |   | D3911  | SHEET 1 OF 3 |
| APPROVED   |   | TITLE  | SCALE        |
| DE APPR.   |   | AFT HARDPOINT, BASKET  | NTS          |
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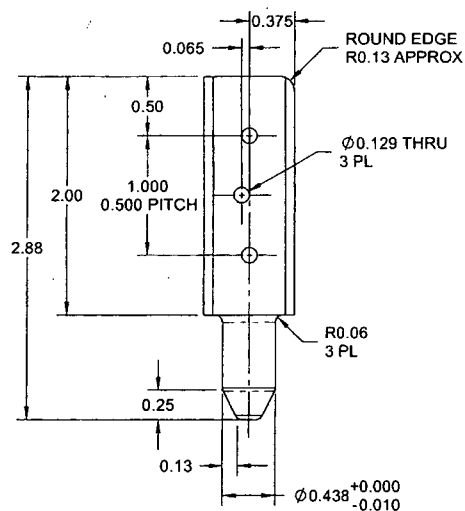
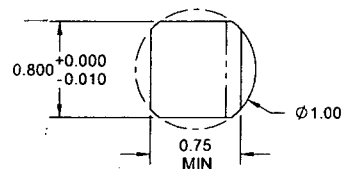
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



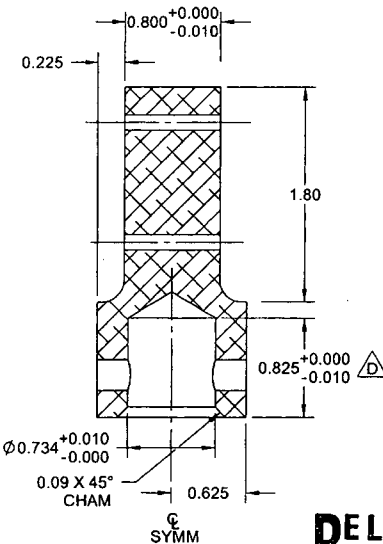
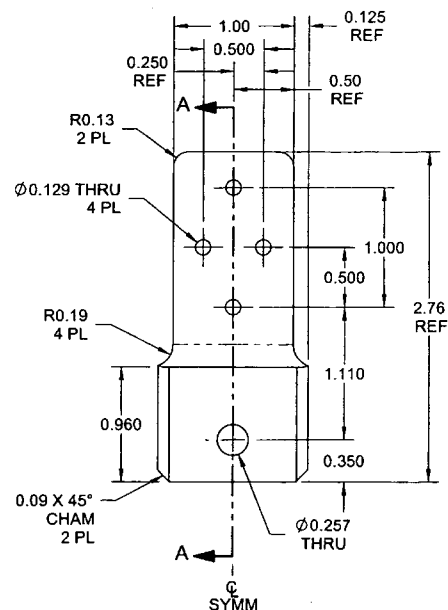
0.09 X 45° CHAMFER

1.250

1.250

0.625 REF

SYMM



RELEASED  
2010-08-04

1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R  
-3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B

- 2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY AT ASSEMBLY  
7) WEIGHT -1: 0.36 lbs  
              -3: 0.71 lbs

|            |                    |   |              |
|------------|--------------------|---|--------------|
| DESIGN     | JPH                | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      |                    | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.   | REV. D       |
| MFG. APPR. | <i>[Signature]</i> | D3911   | SHEET 2 OF 3 |
| APPROVED   | <i>[Signature]</i> | TITLE   | SCALE        |
| DE APPR.:  | <i>[Signature]</i> | <b>AFT HARDPOINT, BASKET</b>  |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



RELEASED  
2010-08-04  
MNO

NOTES:

- NOTES:
- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
  - 7) WEIGHT--5: 0.13 lbs  
--7: 0.13 lbs

|            |                    |   |              |
|------------|--------------------|---|--------------|
| DESIGN     | JPH                | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      |                    | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.   | REV. D       |
| MFG. APPR. | <i>[Signature]</i> | D3911   | SHEET 3 OF 3 |
| APPROVED   | <i>[Signature]</i> | TITLE   | SCALE        |
| DE APPR.   | <i>[Signature]</i> | AFT HARDPOINT, BASKET   | NTS          |
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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries